



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3290-1
Job Sheet 172814



Part No: D3290-1

Job Qty: 6 ea

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/10/18	3/10/18	0.00	0.00	Start Up Waterjet		SC 18/03/04
100	Waterjet	6 pcs	3/10/18	3/10/18	0.00	1.26	Waterjet1		SC 18/03/04
120	QC	6 pcs	3/10/18	3/10/18	0.00	0.00	QC8		38
130	HandFinish	6 pcs	3/10/18	3/10/18	0.00	0.41	HandFinish1		SA 18-03-06
135	QC	6 pcs	3/10/18	3/10/18	0.00	0.00	QC7-2		KL 18-3-07
140	Powdercoat	6 pcs	3/12/18	3/12/18	0.00	0.29	Powdercoat1		AL DAS 3-07
150	QC	6 pcs	3/12/18	3/12/18	0.00	0.00	QC3		11 MAR 08
180	Packaging	6 pcs	3/12/18	3/12/18	0.00	0.00	Packaging3-1		9.89 MAR 13 2018
190	QC21-SA	6 Ea	3/12/18	3/12/18	0.00	0.00	QC21		DAS 21 MAR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	22.5000 sf (3.75 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	23	252	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches ± 0.030	29.030 28.970	29.00	
2	Window Frame	14.000inches ± 0.030	14.030 13.970	14.08	
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170	0.172	
4	Window Frame	1.500inches ± 0.030	1.530 1.470	1.501	
5	Window Frame	1.110inches ± 0.030	1.140 1.080	1.112	
6	Window Frame	10.100inches ± 0.030	10.130 10.070	10.102	
7	Window Frame	18.500inches ± 0.030	18.530	18.503	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Screen ☐ Use: _____ Suspected Unappr ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier ☐</td> <td>Other ☐</td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Other ☐																																										
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Date : _____		Step #: _____		MRB (QSI042) Approval																																																											
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			18.470	
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	0,062
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	3,004
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	4,506
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256	0,258
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	13,612

Plex 2/22/18 6:12 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					